



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Order 410+ JUNE 5

RBW6305G00132-3G

Job Sheet 175864



Part No: RBW6305G00132-3G

Job Qty: 1 ea

Part Name: AW139 Gimbal Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 6/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G00132-3G Rev 4 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
60	Purchasing	1 pcs		6/4/18	0.00	0.00	Purchasing Start Up		APR 18/05/18
70	Packaging	1 pcs		6/4/18	0.00	0.00	Packaging2		APR 18/05/18
80	QC	1 pcs		6/4/18	0.00	0.00	QC6		ES
90	Small Fab	1 pcs		6/4/18	0.00	0.00	Small Fab-4		MCC
110	Small Fab	1 pcs		6/5/18	0.00	0.25	Small Fab-4		MCC DAS
120	QC	1 pcs		6/5/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		6/5/18	0.00	0.00	Packaging3-1		CAISS 18-06-01
140	QC21-FG	1 Ea		6/5/18	0.00	0.00	QC21		21 JUN 04 2018

Part Op 60 - Issue PO to ARROW TECH MACHINE WORKS P/O: 39580 MANUFACTURE RBW6305G00132-3G AS PER

Descriptions: DWG. -Certificate of conformity is required

110 - 1-Glue placard RBW6305G00132-3G-11 to RBW6305G00132-3G-9 foam as per DWG. 2-Glue foam to case and pack case as per DWG.

x1

MAY 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G00132-3GP	AW139 Gimbal Bushing	1 pcs (1 ea)	60-Purchasing	52740767
APP-1120-E	Case	1 Ea (1 ea)	90-Small Fab	5060688
RBW6305G00132-3G-11	Placards	1 Ea (1 ea)	90-Small Fab	5067131
RBW6305G00132-3G-7	Bottom Foam	1 Ea (1 ea)	90-Small Fab	5060690
RBW6305G00132-3G-9	Top Foam	1 Ea (1 ea)	90-Small Fab	5060691
RBW6305G00232-3G	Gimbal Torque Tube Bushing Installer	1 Ea (1 ea)	90-Small Fab	
RBW6305G01232-3G	Gimbal Torque Tube Bushing Remover	1 Ea (1 ea)	90-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
60-Purchasing	RBW6305G00132-3GP	1	0	0
90-Small Fab	APP-1120-E	1	0	0
	RBW6305G00132-3G-11	1	0	0
	RBW6305G00132-3G-7	1	0	0
	RBW6305G00132-3G-9	1	0	0
	RBW6305G00232-3G	1	0	0
	RBW6305G01232-3G	1	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hewkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S074077



Part: RBW6305G00132-3G

Job No: 175864

Serial No/Batch: S074077

Revision: 4

Inspector:

Date: 05/24/18

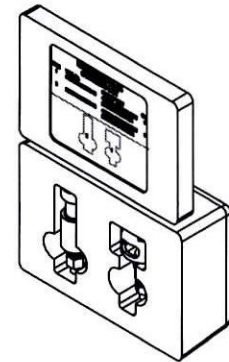
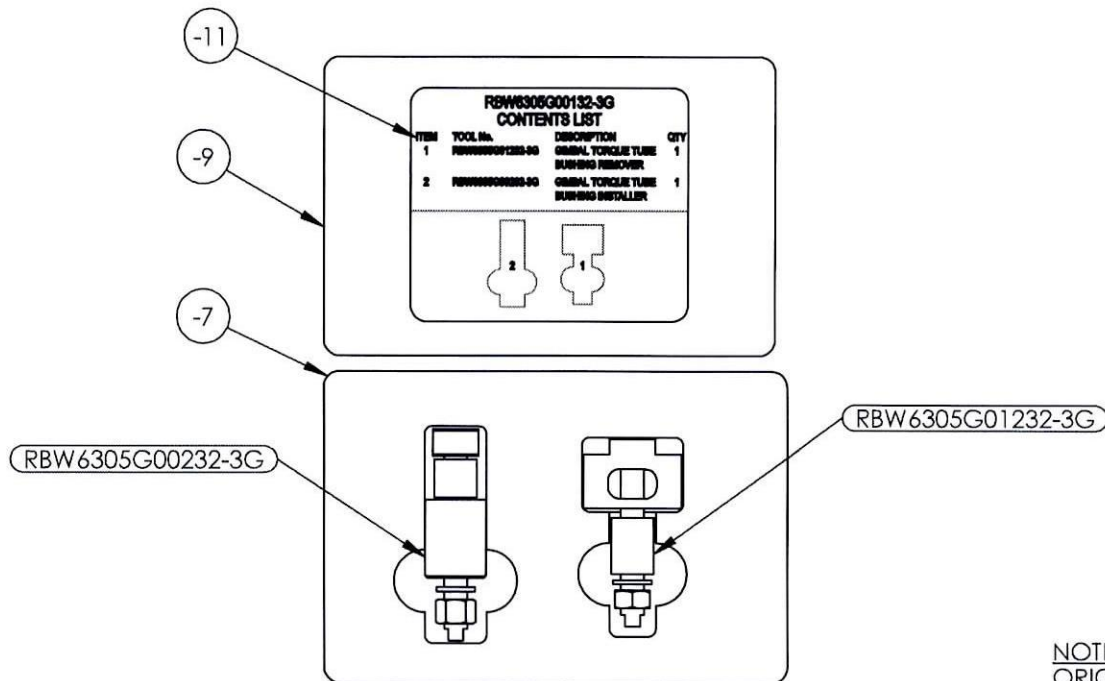
38
1000

Specifications could not be found.

Plex 4/11/18 11:21 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-29 CH'D THICKNESS FROM .31. -31 CORRECTED TOOL NUMBERS.	5/11/2011	RJC	RW
3		-7 CH'D CUTOUTS FROM .87 TO 1.00, AND 1.60 TO 1.62. ADDED FINGER GRAB CUTOUTS. -9 CH'D PLACARD CUTOUT DEPTH FROM .07 TO .10.	10/29/2012	RJC	SE
3A		-7 CH'D DIM WAS R.125 IS R.13. -9 ADDED SECTION A-A, CH'D DEPTH WAS .10 IS .13, CH'D DIM WAS R.375 IS R.38. -11 CH'D DIM WAS .06 IS (.06).	5/5/2014	DPD	RJC
4	15-0322	-9 CH'D DIMS WAS 4.75 IS 4.80, WAS 7.13 IS 7.30, WAS .40 IS .72, WAS 6 IS 4.50, WAS 3.00 IS 3.75 WAS 4X R.38 IS 4X R.25. -11 CH'D DIMS WAS 2.50 IS 3.75, WAS 6.00 IS 4.50 WAS R.38 IS R.25. ADDED TOOL OUTLINES & ITEM NUMBERS.	10/5/2015	RJC	JAG



NOTES:
ORIGINAL No. FOR REFERENCE ONLY:
RBW6305G00132-3G = 3G6305G00132

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GIMBAL TORQUE TUBE BUSHING REMOVER		RBW6305G01232-3G	1
				1	GIMBAL TORQUE TUBE BUSHING INSTALLER		RBW6305G00232-3G	1
		B/O	-5	1	CASE	PLASTIC	PELICAN #APP1120-E	N/S
		B/O	-7	1	BOTTOM FOAM	Y20 BLACK	2-5/8 X 5 X 7-1/2 I.R. SPECIALTY FOAM	2
		B/O	-9	1	TOP FOAM	Y20 BLACK	23/32X 4-3/4 X 7-5/16 I.R. SPECIALTY FOAM	3
			-11	1	PLACARD	PLASTIC		4

DART AEROSPACE	
TITLE GIMBAL BUSHING KIT	
DWG NO. RBW6305G00132-3G	REV 4
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERITT APPROVED: <i>D. Weir</i> TREAT FINISH SPEC USED ON MODEL AGUSTA	
SCALE 1:3	DATE 1/13/2009 SHEET 1 OF 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039580**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039580

PO Date: 4/11/18

Due Date: 6/2/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

REVISED

\$

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RBEGM-745-064P			Removal/Installation-Motor Pump Cartridge (Forward Main Tank) WO 175829 AND WO 175826	Firmed	5/11/18	2 Ea	0 Ea	2 Ea	\$1,736.93/Ea	\$3,473.86
2	RBW109-3130-85-133P			Tool Kit, Tail Rotor Pitch Control Shaft Bearing Remove/Install WO 175827 AND WO 175893	Firmed	5/25/18	2 Ea	0 Ea	2 Ea	\$1,766.68/Ea	\$3,533.36
3	RBEL133M-6503-101P			Mounting Tool	Firmed	5/18/18	2 Ea	0 Ea	2 Ea	\$1,753.73/Ea	\$3,507.46
4	RBD29828P			Elastomeric Bearing Removal Tool WO 175825	Firmed	6/4/18	2 Ea	0 Ea	2 Ea	\$551.91/Ea	\$1,103.82
5	RBW6305G00431-3GP			Hoisting Flange Main Gear Box WO 175830	Firmed	5/29/18	4 pcs	0 pcs	4 pcs	\$1,013.90/pcs	\$4,055.60
6	RBE117-11181W1P			Main Rotor Drive Mounting Tool WO 175881, WO 175882, WO 175883, WO 175885	Firmed	5/11/12	4 Ea	0 Ea	4 Ea	\$2,603.98/Ea	\$10,415.92
7	RBW6305G00132-3GP			AW139 Gimbal Bushing WO 175863, WO 175864, WO 175865	Firmed	5/29/18	3 pcs	0 pcs	3 pcs	\$1,080.39/pcs	\$3,241.17



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039580

Dated: 5/23/2018

Our Order / Job No:039580-07AWT

Order Qty: 3

Part Name: GIMBAL TORQUE TUBE BUSHING INSTALLER

Part Number: RBW6305G00132-3G

Lot Size:N/A

Ship Date: 5/23/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

JP

Drawing Number: RBW6305G00132-3G

Rev: 2

Material Size and Type:(RBW6305G00232-3G REV -2)-1,-3,-5,-7/4140 Q&T;
(RBW6305G01232-3G REV-3)-1,-3,-5/4140 Q&T STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish:

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 5/23/18

Signed: *Henri M. Fahl*

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com